

Work Order ID 54815-1

*split*

December 22, 2009 1:26:54 PM

Page 1

Item ID: D3709-3

Accept

Revision ID:

Item Name: Angle

Start Date: 1/05/10

Start Qty: 3

Required Date: 1/15/10

Req'd Qty: 6.00

Reference:

Approvals:

Process Plan: *CL*

Date: *09/12/23* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3709

Rev A

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3709 Dwg Rev: *A* Prog Rev: *A*

*6061 - CC3*

\*\*\*\*grain direction on a 45 degree \*\*\*\*  
necessary

2- Deburr if

*RB 10-1-7*

*(10)*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

*RB 10-1-17*

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

*77 81061/07*

*(10)*

# Work Order ID 54815

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Page 2

Item ID: D3709-3

Revision ID:

Item Name: Angle

Start Date: 1/05/10

Start Qty: 6.00

Required Date: 1/15/10

Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Form as per dwg D3709

0.00

0.00

SD 10/03/01

(3)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

SD 10/03/03

(43)

150



Hand Finish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

BK 10-03-08

(3)

# Work Order ID 54815

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Page 3

Item ID: D3709-3

Revision ID:

Item Name: Angle

Start Date: 1/05/10

Start Qty: 6.00

Required Date: 1/15/10

Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

*ed 10/03/05*

*(B) 7*

170



Packaging

Packaging

Identify as per dwg & Stock Location *83*

Memo

0.00

0.00

*10-3-3 (B) 7*

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

*10/03/05 KJ*

*MF 10-3-4*

# Picklist Print

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Page 1

Work Order ID: 54815



Parent Item: D3709-3



Parent Item Name: Angle

Start Date: 1/05/10

Required Date: 1/15/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

55.7377

1.6800

3



FB 10-1-7

6061-T6 .063 Sheet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

55.73772105

110551

29.6341211

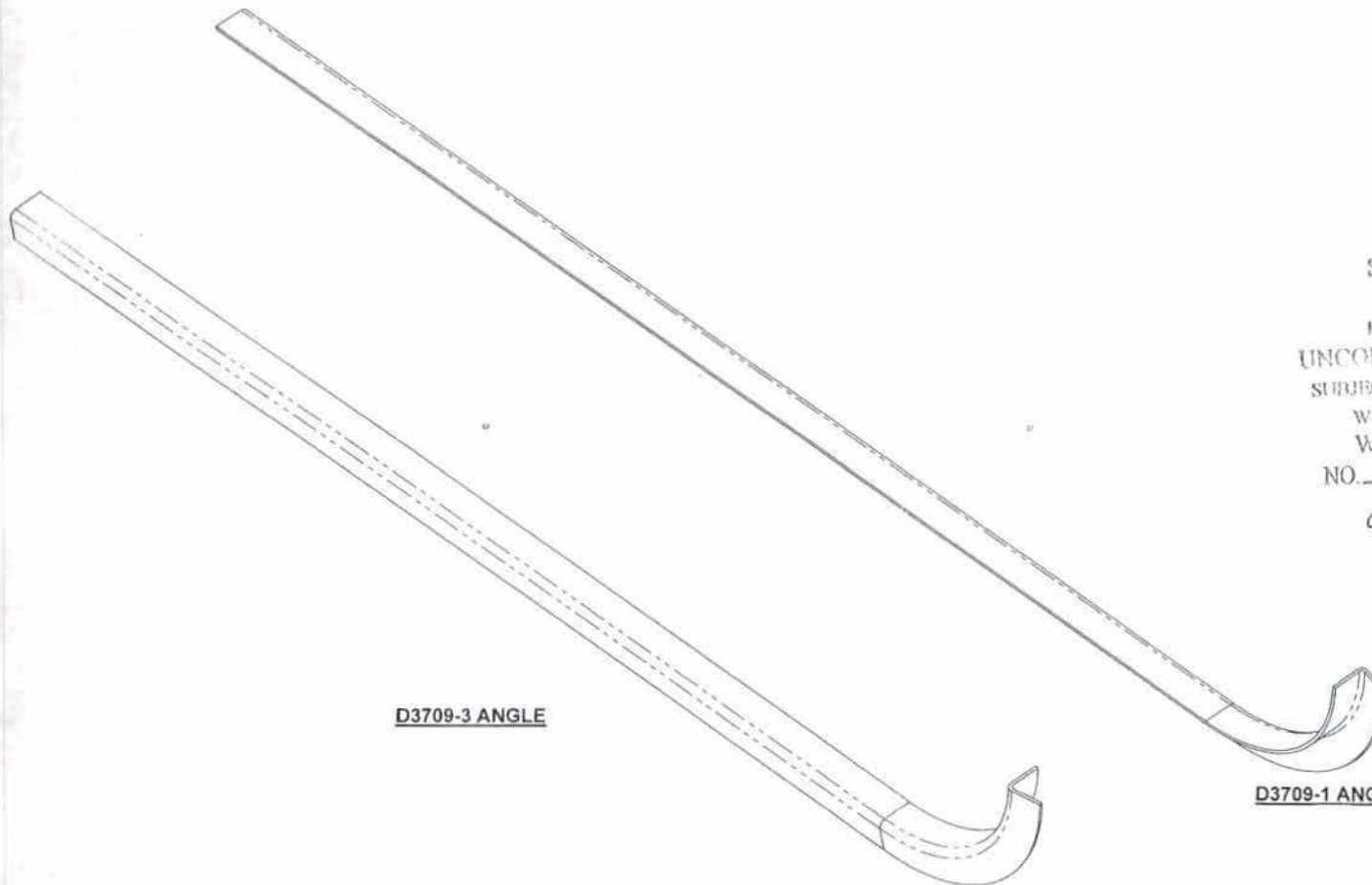
112939

26.1036

112939







**D3709-3 ANGLE**

**D3709-1 ANGLE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54815

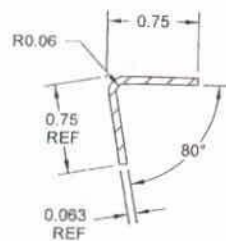
0209112123

**RELEASED**  
09/04/19/17

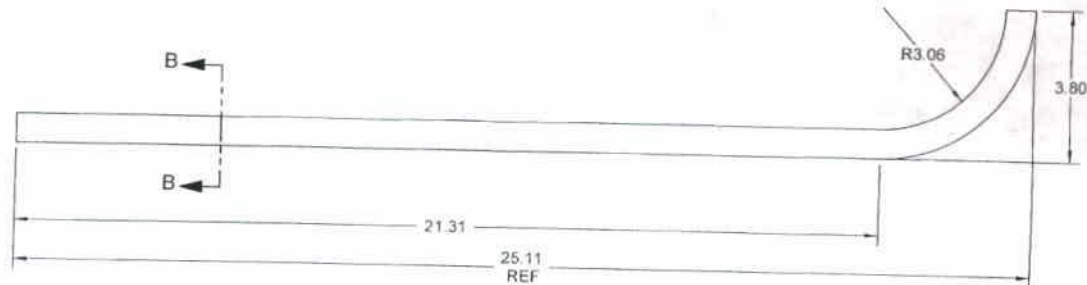
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3709-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3709-1 = 0.24 lbs  
D3709-3 = 0.16 lbs

A		NEW ISSUE		MB	08.05.02
REV		DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN				SHEET 1 OF 3	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.		DRAWING NO. <b>D3709</b>		TITLE <b>ANGLE</b>	
DATE	08.05.02	COPYRIGHT © 2008 BY DART AEROSPACE LTD		THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

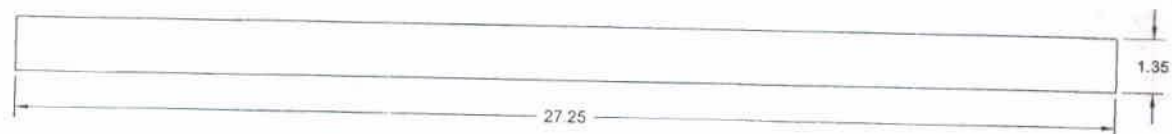


SECTION B-B  
SCALE 2X



D3709-3 ANGLE  
(MAKE FROM D3709-3F)

GRAIN  
DIRECTION



D3709-3F ANGLE FLAT PATTERN

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 54815

RELEASED  
07/04/91

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3709	SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.			ANGLE	NTS
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